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|                           |                     |                    |
|---------------------------|---------------------|--------------------|
| <b>DART AEROSPACE LTD</b> | <b>Work Order:</b>  | 21510              |
| <b>Description: Plug</b>  | <b>Part Number:</b> | D2594-1            |
| <b>Dwg: D2594 Rev. B1</b> | <b>Qty:</b>         | 500 <del>495</del> |
|                           |                     | Page 1 of 1        |

| Step | Location | Procedure   | By | Date     | Qty |
|------|----------|---|----|----------|-----|
| 1    | DC       | Issue Traveller   | HA | 04.09.16 | 500 |
| 2    | MC       | Make as per Dwg D2594-1 and Folio FA262.<br>Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)<br>1100-0 (QQ-A-225/1) Ø0.625" Rod<br>(M5052H32R0.625) or (M6061T6R0.625)<br>Batch M15709 | SL | 04/10/14 | 497 |
| 3    | MC       | Break all sharp edges 0.010 max.  | SL | 04/10/14 | 497 |
| 4 A  | QC2      | Inspect dimensions as per drawing D2594   | SL | 04/10/14 | 497 |
| 4 B  | QC8      | Second check  | SL | 04.10.14 | 495 |
| 5    | FP       | Acid etch and alodine as per QSI 005 4.1  | ML | 04-10-16 | 497 |
| 6    | FP       | Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3<br>(only larger dia. section necessary) M14658  | ML | 04 11 JL | 497 |
| 7    | QC3      | Inspect Powder Coat   | 2  | 04.11.02 | 497 |
| 8    | FP       | Identify and Stock  | JL | 04-11-02 | 495 |
| 9    | AC       | Cost / part 27  | SL | 04-11-05 | 495 |
| 10   | DC       | Close W/O , 38<br>Inspect Level 21  | HA | 01.11.08 | 495 |

| Rev | Date     | Change   | Revised By | Approved |
|-----|----------|--|------------|----------|
| A   | 98.11.27 | New Issue                                      | DM         |          |
| B   | 00.11.01 | Removed P/O for Powder Coat – in house process | EC         |          |
| C   | 01.07.17 | Reformat step 2                                | SM         |          |
| D   | 02.08.22 | Make in Cobra                                  | KJ RF      |          |

RELEASED  
02/08/22 RF

RF  
02/10/07

CL

| Work Order: |      | WORK ORDER CHANGES |    |      |     |                                   |                          |
|-------------|------|--------------------|----|------|-----|-----------------------------------|--------------------------|
| DATE        | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Manuf /<br>Design Mgr | Approval<br>QC Inspector |
|             |      |                    |    |      |     |                                   |                          |
|             |      |                    |    |      |     |                                   |                          |

| NCR  |      | WORK ORDER NON-CONFORMANCE     |                                |  |                |                           |                        |                          |
|------|------|--------------------------------|--------------------------------|--|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>section A | Corrective Action<br>Section B |  | Sign &<br>Date | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                | Initial                        |  |                |                           |                        |                          |
|      |      |                                |                                |  |                |                           |                        |                          |
|      |      |                                |                                |  |                |                           |                        |                          |
|      |      |                                |                                |  |                |                           |                        |                          |

PAR#:\_\_\_\_\_ Fault Category:\_\_\_\_\_ DQA:\_\_\_\_\_ Date:\_\_\_\_\_

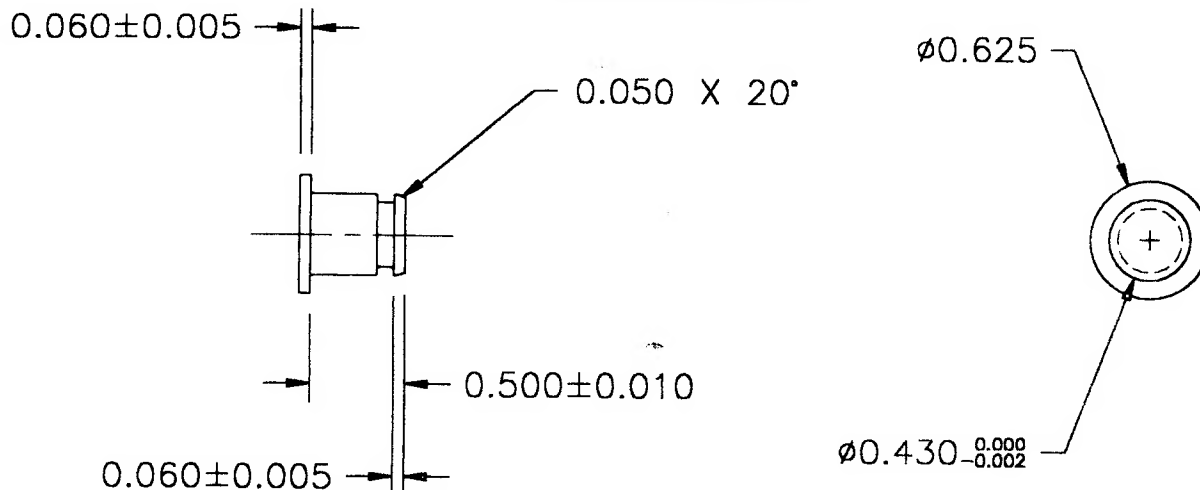
QA: N/C Closed:\_\_\_\_\_ Date:\_\_\_\_\_



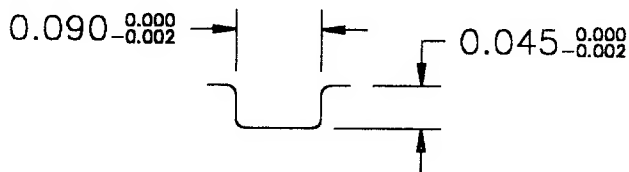


|                      |                        |  |                        |
|----------------------|------------------------|--|------------------------|
| DESIGN<br><i>max</i> | DRAWN BY<br><i>max</i> | DART AEROSPACE LTD<br>VICTORIA INTERNATIONAL AIRPORT, CANADA |                        |
| CHECKED<br><i>BW</i> | APPROVED<br><i>max</i> | DRAWING NO.<br>D2594   | REV. B<br>SHEET 1 OF 1 |
| DATE<br>96:09:16     |                        | TITLE<br>PLUG  | SCALE<br>1:1           |
| B                    | 97:03:15               | ADD GROOVE AND O-RING  |                        |
| B1                   | RF 02.08.26            | ADD POWDER COAT, QSI 018, & QQ-A SPECS.                      |                        |

D2594-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



TOLEANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

FINISH: ACID ETCH, ALODINE

POWDER COAT WHITE (REF. 43.5.1) PER QSI 005 4.3

PER QQ-A-225/7 (5052)  
OR QQ-A-225/8 (6061)  
OR QQ-A-225/1 (1100)  
OR QQ-A-200/8 (6061)



SHOP COPY

RETURN TO  
ENGINEERING

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH  
(PARKER 2-011)

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

D2594 PLUG ASSEMBLY INCLUDES: (1) D2594-1 PLUG  
(1) D2594-3 O-RING

WORK ORDER  
No. 21510

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Sep 16, 2004  
07:37 am

Work Order No : 0021510  
Project Name : D2594-1  
Project For : WK443  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2594-1  
Description : Plug  
Manufactured : Yes  
Amount Req'd : 500  
Amount Done : 0  
Start Date : 09-15-04  
Est Finish Date : 10-22-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

|                     | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost :     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Engineering Hours : | 0.00      | 0.00   | 0.00   |        |         |
| Engineering Cost :  | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Production Hours :  | 0.00      | 0.00   | 0.00   |        |         |
| Production Cost :   | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Packaging Hours :   | 0.00      | 0.00   | 0.00   |        |         |
| Packaging Cost :    | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| OverHead Hours :    | 0.00      | 0.00   | 0.00   |        |         |
| OverHead Cost :     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| CNC Hours :         | 0.00      | 0.00   | 0.00   |        |         |
| CNC :               | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Misc. Hours :       | 0.00      | 0.00   | 0.00   |        |         |
| Misc. :             | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Burden :            | 0.00      | 0.00   | 0.00   |        |         |
| Total Cost :        | 0.00      | 0.00   | 0.00   |        |         |
| Margin :            | 0.000     | 0.000  |        |        |         |
| Selling Cost :      | 0.00      | 0.00   |        |        |         |

|                          | Estimated | Actual |
|--------------------------|-----------|--------|
| Labour Hrs/Amount Done : | 0.00      | 0.00   |
| Profits/(Loss) :         | 0.00      | 0.00   |